



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

646.3510

Job Sheet 170462



Part No: 646.3510

Job Qty: 12 ea

Part Name: Strut



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/16/18

Job Tracking No:

Created By: Linda Lacelle

Due Date: 2/8/18

Type: SOLD

Description:

Note: DWG REV N/C 3 IPP REV:A 12.10.19 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		2/7/18	0.00	0.00	Start Up Waterjet		PC 18/01/27
110	Waterjet	10 pcs		2/7/18	0.00	0.39	Waterjet1		PC 18/01/27
120	QC	10 pcs		2/7/18	0.00	0.00	QC2 Waterjet-1		PC 18/01/27
130	QC	10 pcs		2/7/18	0.00	0.00	QC8-1		PC 18/01/27
140	Small Fab	10 pcs		2/7/18	0.03	4.12	Small Fab-1		PC 18/02/01
150	QC	10 pcs		2/7/18	0.00	0.00	QC5		PC 18/02/06
160	Large Fab	10 pcs		2/7/18	0.00	11.76	Large Fab 1		PC 18-02-12
170	QC	10 pcs		2/7/18	0.00	0.00	QC9		PC 18-02-12
180	QC	10 pcs		2/7/18	0.00	0.00	QC5		PC 18-02-12
220	SprayPaint	10 pcs		2/8/18	0.00	0.37	Spray Paint		PC 18-02-12
230	QC	10 pcs		2/8/18	0.00	0.00	QC14		PC 18-02-12
240	Packaging	10 pcs		2/8/18	0.00	0.00	Packaging3-1		PC 18-02-12
250	QC21-SA	10 Ea		2/8/18	0.00	0.00	QC21		PC 18-02-12

Part Op 110 - 1-Cut 646.3500 plate 2.75"x 1.50" as per Dwg Prog Rev: _____ 2-Deburr if necessary
Descriptions: 140 - 1- Fabricate tube as per dwg USE DT10290 PUNCH

160 - Weld tube to plate as per dwg. DT9867 Weld end were tube is punch.

220 - Prime as per dwg (see note 3) Batch: 138802

240 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV***

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M304S16GA	0	127	0	0
140-Small Fab	M304TR0.500W.049	8	129	0	0

600259

5017/38 = 2.75

5034342 = 6.37

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Strut	2.750Inches ± 0.030	2.780 2.720		
2	Strut	1.500Inches ± 0.030	1.530 1.470		
3	Strut	0.063Inches ± 0.010	0.073 0.053		

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



Work Order update only ☐

POSITION

Rev
Use
Inapp

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA

TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

AGAINST DEPARTMENT/PROCESS

Water Jet ☐
Eng. Coord. ☐
Packaging ☐
Supplier ☐

Engineering ☐
Quality ☐
Other ☐

MRB (QSI042) Approval

Completed By

Lead hand / Supervisor
Approval Verification

QC / QA Coordinator
Approval

Job No 170462

Job No



Master Unit 000264

DART
AEROSPACE
S036174



Strut

PART NO: 646.3510
Original Serial #: S036174
Revision:
Operation:
Change No:

Start up Operation 01/27/18
Job No: 170462

Power Loss/Surge ☐
Machining/Program ☐
Rain ☐
Weld ☐
Wrong Stock Pulled ☐
Out of Sequence ☐
Off-set ☐
Mislabeled ☐
Fit/Function ☐
Misaligned/off center ☐

Positioned Wrong ☐
Outside Dimensions ☐
Over/Under tolerance ☐
Part Incorrect ☐
Part Lost/Missing ☐
Part Moved ☐
Drawing ☐
Finish ☐
Misread ☐
Turning Sequence ☐

Tribal Knowledge ☐
LOA ☐
Substation ☐
Past Expiry Date ☐
Misidentified ☐

Rushing ☐
Product Improvement ☐
Process Improvement ☐
Manufacturing Process ☐
Past Due ☐

Crushing ☐
Heat Treat ☐
Wave/Twist in Tube ☐
Marks/Chatter ☐

Instructions ☐
Drill Holes ☐

OTHER :